

Work Order ID 61973

Monday, September 13, 2010 11:30:04 AM



Page 1

Item ID: D4084-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Maintenance Step

Start Date: 9/13/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 9/20/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

KL

Date:

10/2/10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4084

A

110

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

HAAS CNC vertical machine #1

1-Machine per folio FA960

FOLIO REV: *A*

DWG REV: *A*

2-Deburr any rough edges

B.A 10/10/21

10

0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

B.A 10/10/21

10

0

130

0.00



QC8- Inspect parts - second check

0.00

QC

Memo

Quality Control

SA 10/10/26

10

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61973

Monday, September 13, 2010 11:30:04 AM



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Item ID: D4084-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Maintenance Step					
Start Date: 9/13/2010	Start Qty: 10.00		Cust Item ID:		
Required Date: 9/20/2010	Req'd Qty: 10.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140	Chemical Conversion Coat per QSI005 4.1	0.00	<i>PR 10-10-26</i>						
	HandFinish	0.00	<i>10.</i>						
Hand Finishing	Memo								

150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum-	0.00							
	Powdercoat	0.00							
Powder Coating	Memo								
	START TIME:	<input type="checkbox"/> OVEN TEMPERATURE:							
	FINISH TIME:								

160	QC3- Inspect Part Finish	0.00							
	QC	0.00							
Quality Control	Memo								

= 7 JH 10/10/26

N/A
10-10-25
AS PER CAR.
10-24

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61973

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Monday, September 13, 2010 11:30:04 AM

Item ID: D4084-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Maintenance Step

Start Date: 9/13/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 9/20/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 	Identify as per dwg & Stock Location: <u>119</u>	0.00							
Packaging	Memo	0.00							
Packaging									
180 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/10/27 102

10/10/28
MF
10-10-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, September 13, 2010 11:30:08 AM

Page 1

Work Order ID: 61973



Parent Item: D4084-1



Parent Item Name: Maintenance Step


Start Date: 9/13/2010

Required Date: 9/20/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 10-09-16 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 		Manufactured	No				Each	43.0000	1	10			
Saddle Billet, 7075													

Location

Loc Qty

Loc Code

MAT042

43

59196

3

61250

40

10.0

A-A 10/10/25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

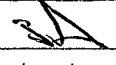
NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 61973
Description: MAINTENANCE STEP		Part Number: D4084-1
Inspection Dwg: D4084 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST


Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.891	+ .010 / - .001	0.894	✓		Vern	GA-01
0.080	+/- .010	0.072	✓		H-6	31006
Ø 0.991 x 45°	+/- .010	Ø 0.996 x 45°	✓		Vern	GA-01
1.40	+/- .030	1.399	✓		H-6	31006
0.89	+/- .030	0.899	✓		Vern	GA-01
0.66	+/- .030	0.658	✓		"	"
1.73	+/- .030	1.736	✓		Vern	GA-01
3.63	+/- .030	3.630	✓		"	"
2.25	+/- .030	2.249	✓		"	"
1.13	+/- .030	1.129	✓		H-6	31006
0.25	+/- .030	0.248	✓		Mic	118-120
2.60	+/- .030	2.600	✓		Vern	GA-01
0.50	+/- .030	0.500	✓		Mic	118-120
R 0.13	+/- .030	R 0.125	✓		R-6	ref.
0.92	+/- .030	0.919	✓		Vern	GA-01
Ø 0.75	+ .008 / - .001	Ø 0.750	✓		"	"
0.97	+/- .030	0.967	✓		H-6	31006
2.650	+/- .010	2.648	✓		Vern	GA-01
4.00	+/- .030	4.000	✓		H-6	31006
Ø 0.339	+ .006 / - .001	Ø 0.342	✓		Vern	GA-01
Ø 0.850	+/- .010	0.850	✓		"	"
0.27	+/- .030	0.269	✓		Vern	GA-01
0.038	+/- .010	0.037	✓		H-6	31006

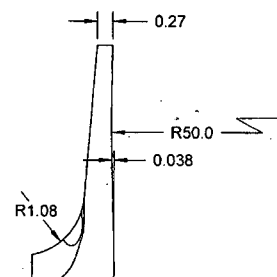
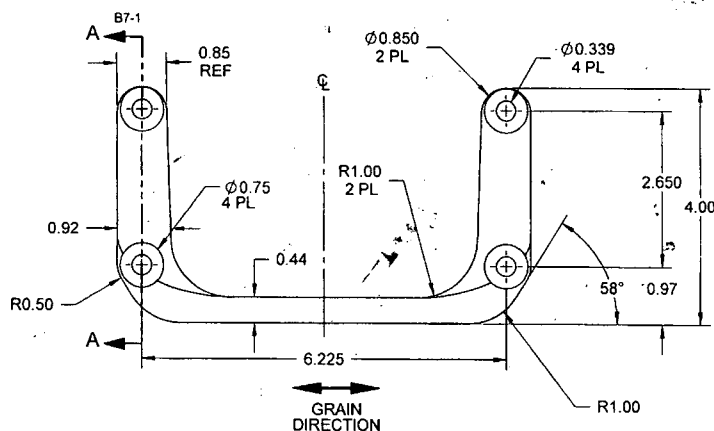
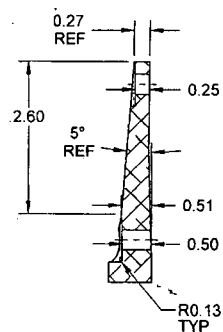
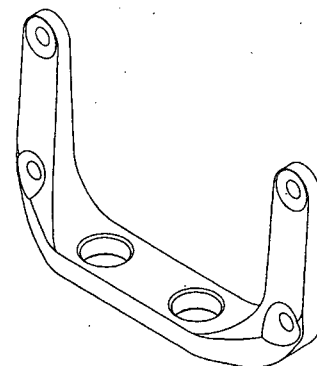
Measured by: J. A
Date: 10/10/25

Audited by: 
Date: 10/10/26

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

 10.04.15



D4084-1 MAINTENANCE STEP

STAMP COPY

A	NEW ISSUE		RF	10.04.12
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D4084 TITLE MAINTENANCE STEP	REV.	
DRAWN	RF		SHEET 1 OF	
CHECKED	<i>[Signature]</i>		SCALE	
MFG. APPR.	<i>[Signature]</i>		NT	
APPROVED	<i>[Signature]</i>			
DE APPR.	<i>[Signature]</i>			
DATE	10.04.12		COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	

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WITH MY FIVE
WORKS FOR
NO. 64973

Pl 109-13